

Work Order ID 120089

120089

Page 1

July-02-14 7:21:13 AM

Item ID: D500-572-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 6/04/14 Start Qty: 2.00

**

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 2.00

**

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-06-03 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2435	Rev E1
-------	--------

IIND500-572	RevA
-------------	------

JB

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

DAS
06
9-89

JUL 07-2014

MLJ 14-07-02

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DAS
31
9-89DAS
33
9-89

14-07-02

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Page 2

July-02-14 7:21:13 AM

Item ID: D500-572-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 6/04/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC4- 100% Inspect kits for completeness 0.00

JUL 07 2014

170

QC

Memo

0.00

Quality Control

DAS
06
9-89

180

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD500-572-011 Location: 012

REV. D

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

2 14-07-07

MLJ 14-07-07

14-7-7

Picklist Print

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Work Order ID: 120089

120089

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

QS200-M44S		Purchased	No			120	Each	56.0000	2	4			
✓ *QS200-M44S* CLAMP DAS 06 9-89 Location ST453 119436 125957 m128813 m129499 Loc Qty 56 1 10 15 30 Loc Code 125957 DAS 33 9-89 DAS 31 9-89													

AN4-15A		Purchased	No			170	Each	466.0000	8	16			
✓ *AN4-15A* Bolt DAS 06 9-89 Location GA 120449 ST357 m127817 ST515 122141 m123525 m128403 m128978 Loc Qty 100 100 11 11 355 4 10 141 200 Loc Code 128403 DAS 33 9-89 14-07-02 DAS 31 9-89													

Picklist Print

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Work Order ID: 120089

120089

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 2.00

Required Qty: 2.00

D2182B

Manufactured No

170

f

350.2100 1:666 4

D2182R

Seal(\$Per Foot)

DAS
06
9-89

Location

Loc Qty

Loc Code

ST412

350.21

101827

1

108914

1.21

115189

348

**

DAS

33

9-89

DAS

31

9-89

D2274

Manufactured No

170

Each

446.0000

D2274

Radius Block

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST005

434

109534

6

110264

2

112466

67

115803

359

**

DAS

33

9-89

DAS

31

9-89

D2435

Manufactured No

170

Each

1.0000

D2435

Bearpaw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST269

1

110388

1

**

DAS

32

9-89

14-07-02

DAS

31

9-89

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Shop Packet Print

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Picklist Print

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Work Order ID: 120089

120089

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 2.00

Required Qty: 2.00

D2438

Manufactured No

170

Each

142.0000

4

8

**

DAS

DAS

33

31

9-89

9-89

Clamp

DAS

06

9-89

Location

Loc Qty

Loc Code

ST

126

112483

126

ST456

10

115202

10

ST556

6

32016

6

D2529

Manufactured No

170

Each

1,033.000

8

16

**

DAS

33

9-89

1407-06

Washer

DAS

06

9-89

Location

Loc Qty

Loc Code

ST007

1033

109580

7

115153

326

119633

600

121250

100

DAS

31

9-89

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Shop Packet Print

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Picklist Print

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Work Order ID: 120089

120089

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

170

Each

5,234.000

8

16

**

DAS

DAS

Locknut

DAS

06

9-89

33

9-89

31

9-89

Location

Loc Qty

Loc Code

ST307

5234

121444

12

m126015

12

m126275

32

m127255

71

m127376

11

m127813

971

m128300

80

m128798

3045

m129472

1000

128798

NAS1149D0463J

Purchased

No

170

Each

7,922.000

8

16

**

DAS

14-07-02

WASHER

DAS

06

9-89

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST277

7922

121912

12

16941

8

M126221

20

M127813

22

M127904

1259

M128591

101

M128995

1500

M129390

5000

127904

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Shop Packet Print

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RELEASED
48.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED KE	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	

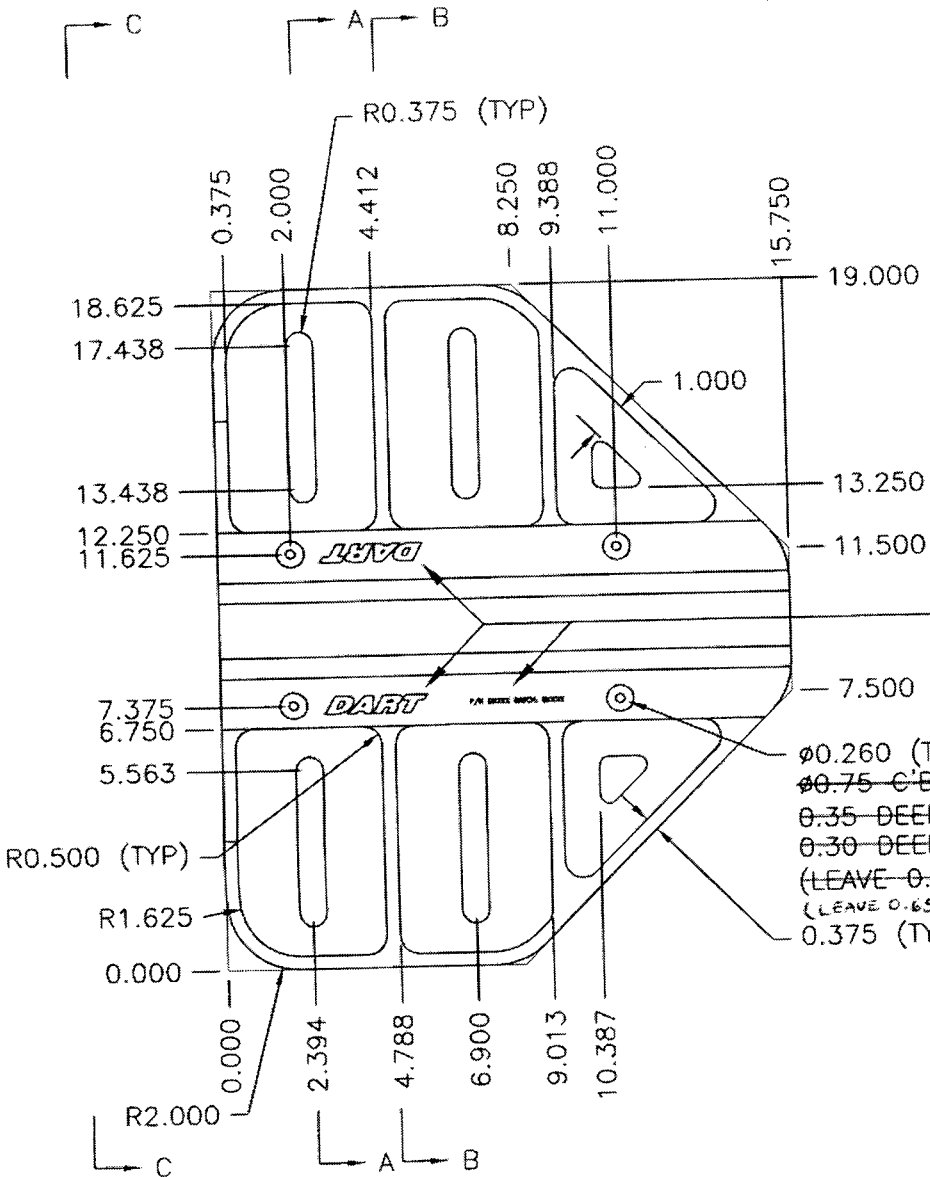
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

120089 MJS
14-06-05

$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 $\phi 0.75$ C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

9143

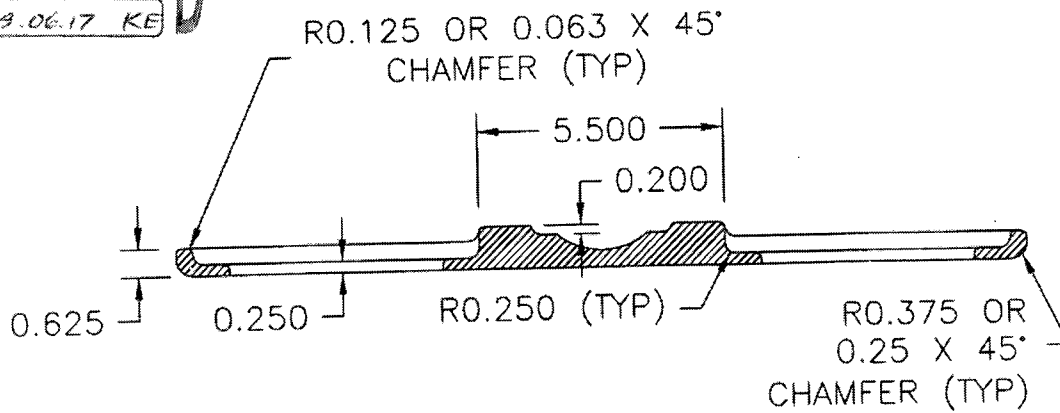


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

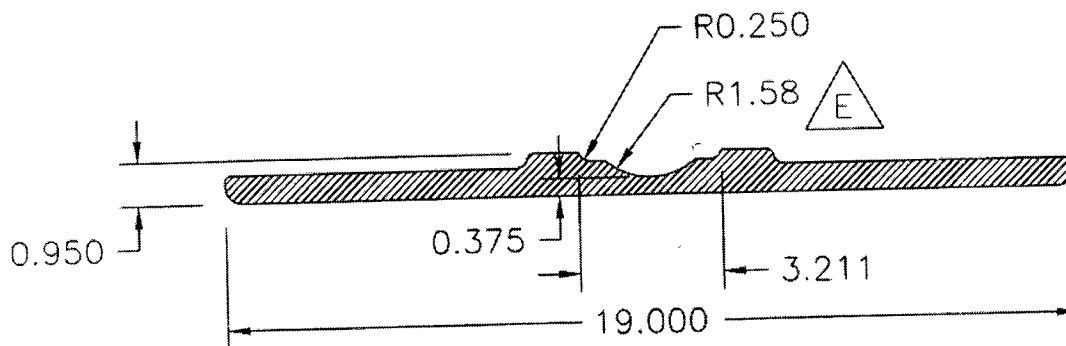


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DDB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

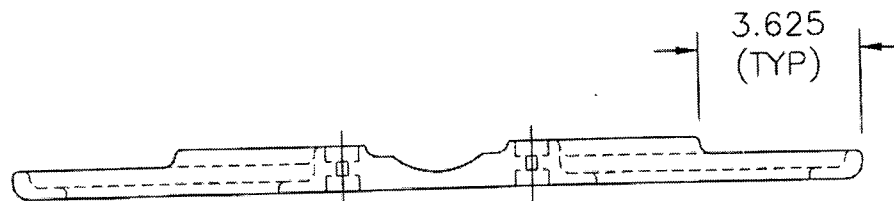
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

DAS
06
9-89

REFERENCE ONLY

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

5. PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
12				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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Revision: A

Date: 01.02.21